

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011890**Date Inspected:** 06-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

TRIAL ASSEMBLY YARD

MAGNETIC PARTICLE INSPECTION

OBG SEGMENT 6AE

This Quality Assurance (QA) Inspector performed Magnetic particle Testing of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (M.T) report for this date. The members are identified as the Segment 6AE (hold back weld) the welds Designation are as follows.

DP513-001-011, 012; EP25-001-016, 017; SP086-001-018, 019; SP525-001-040-041

SP565-001-023, 024; SP605-001-019, 020; BP59-001-034, 035, 040, 041; BP113-001-034, 035, 040, 041;

SP361-001-046, 047, 052, 053; SP426-001-023, 024; SP334-001-50, 51; SP307-001-053, 054, 063, 064;

EP54-001-008, 007; DP635-001-007, 008.

TRIAL ASSEMBLY YARD

WELDING INSPECTION REPORT

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This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 6AE -6BE

This Quality Assurance (QA) Inspector observed ABF inspector performing magnetic particle inspection on the hold back weld area of OBG segment 6AE and 6BE near the bottom panel splice weld between OBG segment 6AE and 6BE.

OBG SEGMENT 7BW-7CW

This Quality Assurance (QA) Inspector observed ZPMC qualified welders 066773, 045280 performing Flux Cored Arc Welding process for weld OBW7C-003 located on PCMK bottom panel splice weld between OBG segment 7BW and 7CW. ZPMC QC Mr. Feng Ying Jing monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231T.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 068917 performing Shielded Metal Arc Welding process for weld OBW7A-005 located on PCMK edge panel splice weld between OBG segment 7BW and 7CW (bike path side). ZPMC QC Mr. Feng Ying Jing monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2-FCM-1.

OBG SEGMENT 6AE

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 216086 performing Shielded Metal Arc Welding process for weld SSD30C-PP40.5-140 located on PCMK edge panel T stiffener at PP40.5 cross beam side. ZPMC QC Mr. Zhang Qing monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G (3F)-Repair. Critical weld repair report identified as B-CWR1205.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar,Shrikant	Quality Assurance Inspector
Reviewed By:	Dawson,Paul	QA Reviewer
